

Work Order ID 51784

September 3, 2009 9:26:29 AM



Page 1

Item ID: D212-580-041

Accept



Setup Start



Revision ID: B2

Stop



Item Name: Cargo Mirror Assembly

Start Date: 9/03/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: UN Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	-Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2161	Rev B2
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100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D212-580-041 CHG003

Solz/uk

Handwritten: 100 BG 09/11/12

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Assemble on Jig DT8065 as per Dwg D2161 12-Weld as per Dwg D2161 Identify as D2161-212 1A/R SS ROD Batch: *100775*

Handwritten: 110 11 11 4x

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Handwritten: 120 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC Memo 0.00

Quality Control

Pl 09 11 11

140 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00



Powdercoat

Powder Coating

Memo

START TIME: 7:45 AM FINISH TIME: 8:15 AM OVEN TEMPERATURE: 320°F

⇒ 11 08/11/12

(X4) ①

150 QC3- Inspect Part Finish 0.00



QC

Quality Control

Memo

pl 09 11-12

(4)

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NOTE: Date & initial all entries

Work Order ID 51784



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September 3, 2009 9:26:30 AM

Item ID: D212-580-041

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Revision ID: B2

Stop



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Start Date: 9/03/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging	Pick Kit	0.00							
Packaging	Memo	0.00							
170 QC	QC4- 100% Inspect kits for completeness	0.00							
Quality Control	Memo	0.00							
180 Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Identify and pack for shipping as per PPP D212--580-041 □ Location: <u>24</u> □ PPP Rev: <u>5</u>									

9/11/12 40 SF

MO 09/11/13 / 501.1.6 24
Lable and kits in Box only

9/11/16 40 SF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 51784

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Start Date: 9/03/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/17 *[Signature]*
MF
09-11-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

September 3, 2009 9:26:27 AM

Page 1

Work Order ID: 51784



Parent Item: D212-580-041RevB2



Parent Item Name: Cargo Mirror Assembly

Start Date: 9/03/09

Required Date: 9/18/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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CCR264SS3-2

Purchased

No

170

Each

278.0000

16.0000



Rivet, Cherry

9/11/12 50 (4x)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

278

108688

62

108738

116

112314

100

16x50

D2011-103RevG

Manufactured

No

170

Each

5.0000

8.0000



8" Mirror

B32198 9/11/12 (4x) 50

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5

43342

5

110

Each

4.0000

4.0000

D2013-3RevC

Manufactured

No



Mirror Bracket LH, 212

sp 09.011.10.

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

51371

4

52274

8x

4x. ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

September 3, 2009 9:26:27 AM

Work Order ID: 51784

Parent Item: D212-580-041RevB2

Parent Item Name: Cargo Mirror Assembly


Comments:

Start Date: 9/03/09

Required Date: 9/18/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2013-4RevC		Manufactured	No			110	Each	4.0000	4.0000			
												
Mirror Bracket RH, 212												

SP 09-11-10

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse 5075	84	
ST	4	
51372	4	

4X. W

D2037-101RevD		Manufactured	No			170	Each	12.0000	4.0000			
												
Arm												

SP 09-11-10

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse 52272		
ST	12	
41854	1	
51373	1	
51440	10	

4X. V

MS21059L3		Purchased	No			170	Each	476.0000	8.0000			
												
Nut Plate												

9/11/10 (4) SP

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	476	
109962	26	
111925	450	

8x50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

September 3, 2009 9:26:27 AM

Work Order ID: 51784



Parent Item: D212-580-041RevB2



Parent Item Name: Cargo Mirror Assembly

Start Date: 9/03/09

Required Date: 9/18/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-08		Purchased	No			100	Each	3,381.000	16.0000			



Screw



9/16/09 WDS

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 3381

110467 192

110552 1189

110835 2000

16x50

W/O:		WORK ORDER CHANGES					
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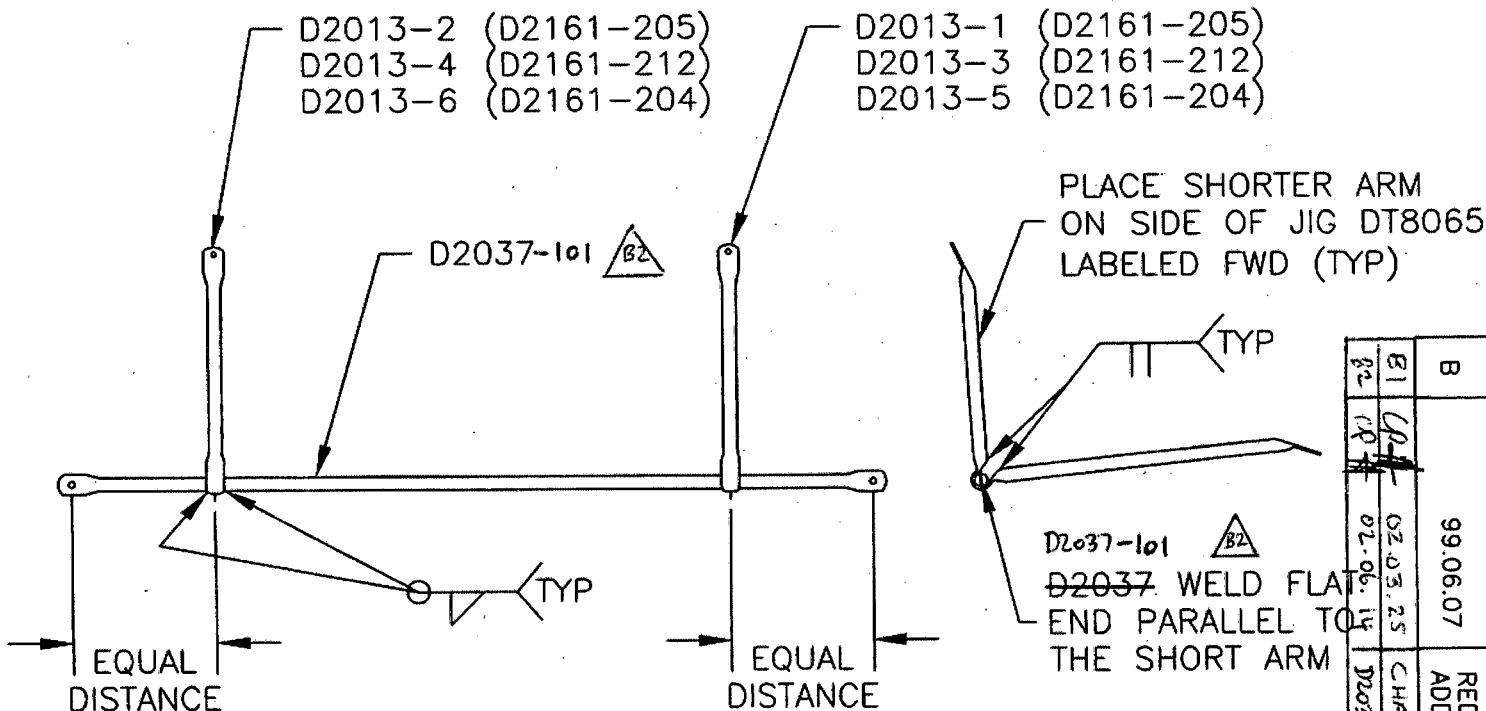
DART



DESIGN	JB	DRAWN BY	RT	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. B
CHECKED	KE	APPROVED	RT	DRAWING NO.	SHEET 1 OF 1
DATE	99.06.07	TITLE	MIRROR BRACKET	SCALE	NTS
A	93.04.29	NEW ISSUE			
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS			
B1	02.03.25	CHANGE FINISH			
B2	07.06.14	D2037-101 W/			

RELEASED
KE 99.06.10

51784



DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK-
CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3 B1

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D204-562-041	5.0 lb	0 in	0 lb-in	3.80 in	19.0 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	0.10 m	0.23 m-kg
D205-563-041	5.0 lb	0 in	0 lb-in	3.80 in	19.0 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	0.10 m	0.23 m-kg
D212-580-041	5.0 lb	0 in	0 lb-in	-5.25 in	-26.3 in-lb
Dual Mirror Installation	2.3 kg	0 m	0 kg-m	-0.13 m	-0.30 m-kg

5.0 PARTS LIST

Qty 562 -041	Qty 563 -041	Qty 580 -041	Part Number	Description
X			D204-562-041	DUAL MIRROR INSTALLATION
	X		D205-563-041	DUAL MIRROR INSTALLATION
		X	D212-580-041	DUAL MIRROR INSTALLATION
2	2	2	D2011-103	MIRROR
1			D2161-204	MIRROR BRACKET
	1		D2161-205	MIRROR BRACKET
		1	D2161-212	MIRROR BRACKET
*2	*2	*2	D3015-3	LOCKNUT
*2	*2	*2	AN960JD516	WASHER
		4	CCR264SS-3-2	RIVET, BLIND
		2	MS21059L3	NUTPLATE
4	4	4	MS27039-1-08	SCREW

* PARTS ARE INCLUDED WITH D2011-103 MIRROR

REFERENCE ONLY

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Revision: C
Date: 08.01.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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